

Work Order ID 70943

Monday, June 20, 2011 8:50:57 AM



Page 1

SHIP JULY 8

Item ID: D3414-041

Accept



Setup

Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 6/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

H

Date: 11/06/20

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3414	Rev C

100

0.00



Waterjet

Memo

0.00

B11-6-20

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B11-6-20

Quality Control

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

QC8- Inspect parts - second check

0.00

S u l o c / 7 /

(X13)

Quality Control

130



Brake NC

Memo

0.00

(13)

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

0.00

S B 116.4/2!

140



Large Fab

Memo

0.00

(2) 167-7.

Large Fab

1- Weld using location Jig DT9625 as per Dwg D3414
A/R S.S. welding rod Batch: M17657

0.00

(X13)

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

175



SprayPaint

Spray Painting

Memo

 PRIME B 117319
 DELFLEET BLUE B 115985
 DELFLEET CLEAR B 117113

0.00

0.00

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

185



QC14- Inspect Spray Paint

0.00

MF 11-07-14 (13)

QC

Quality Control

190

Identify as per dwg & Stock Location: *420*

0.00

MF 11-07-14 (13)

Packaging

Packaging

Memo

0.00

200



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

MF 11-07-14 (13)

MF 11-07-14

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Picklist Print

Monday, June 20, 2011 8:51:04 AM

Page 1

Work Order ID: 70943



Parent Item: D3414-041



Parent Item Name: Lug Assembly

Start Date: 6/20/2011

Required Date: 7/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A□05.09.13□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA 		Purchased	No			100	sf	150.3000	0.155	0.62		18/11-6-20	

304/316 0.100" Sheet

Location	Loc Qty	Loc Code
MAT019	150.3	
113062	118.3	
113077	32	

D3414-3



Manufactured

No

140 Each 21.0000 1 4

Lug

Location	Loc Qty	Loc Code
WA 	21 21	

13

(13)

EL 11-7-7

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	10943
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	1-6-20	Date:	10/04/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	 

W/O:		WORK ORDER CHANGES					
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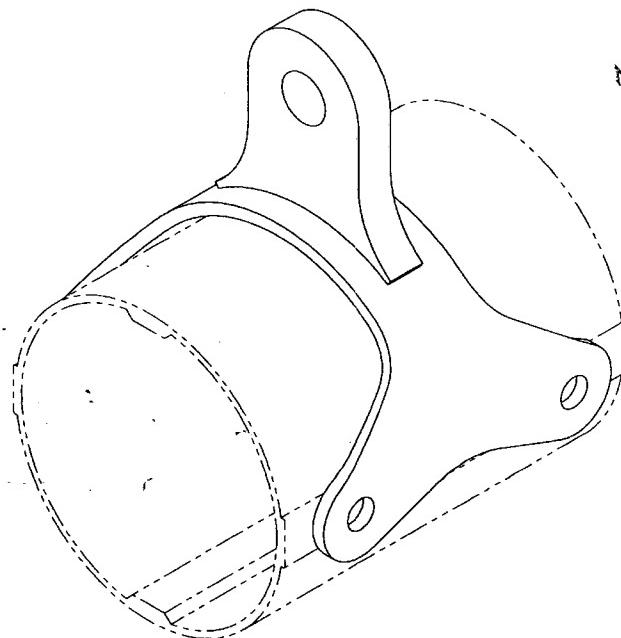
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8 7 6 5 4 3 2 1

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70943
PL/11-06-20



D3414-041 LUG ASSEMBLY

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	OP	DART AEROSPACE LTD	
DRAWN	OP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE WHATSOEVER BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

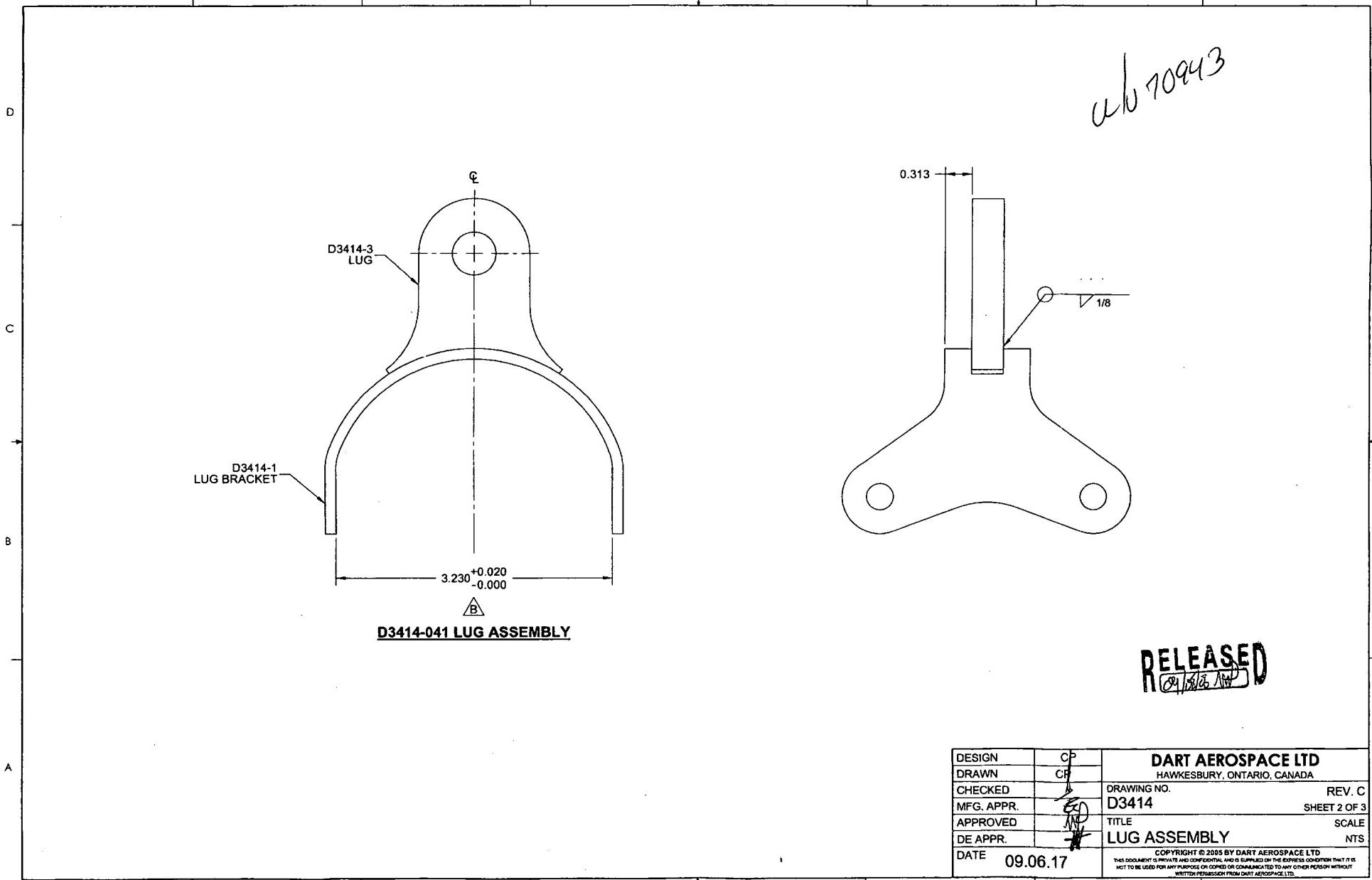
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8 7 6 5 4 3 2 1



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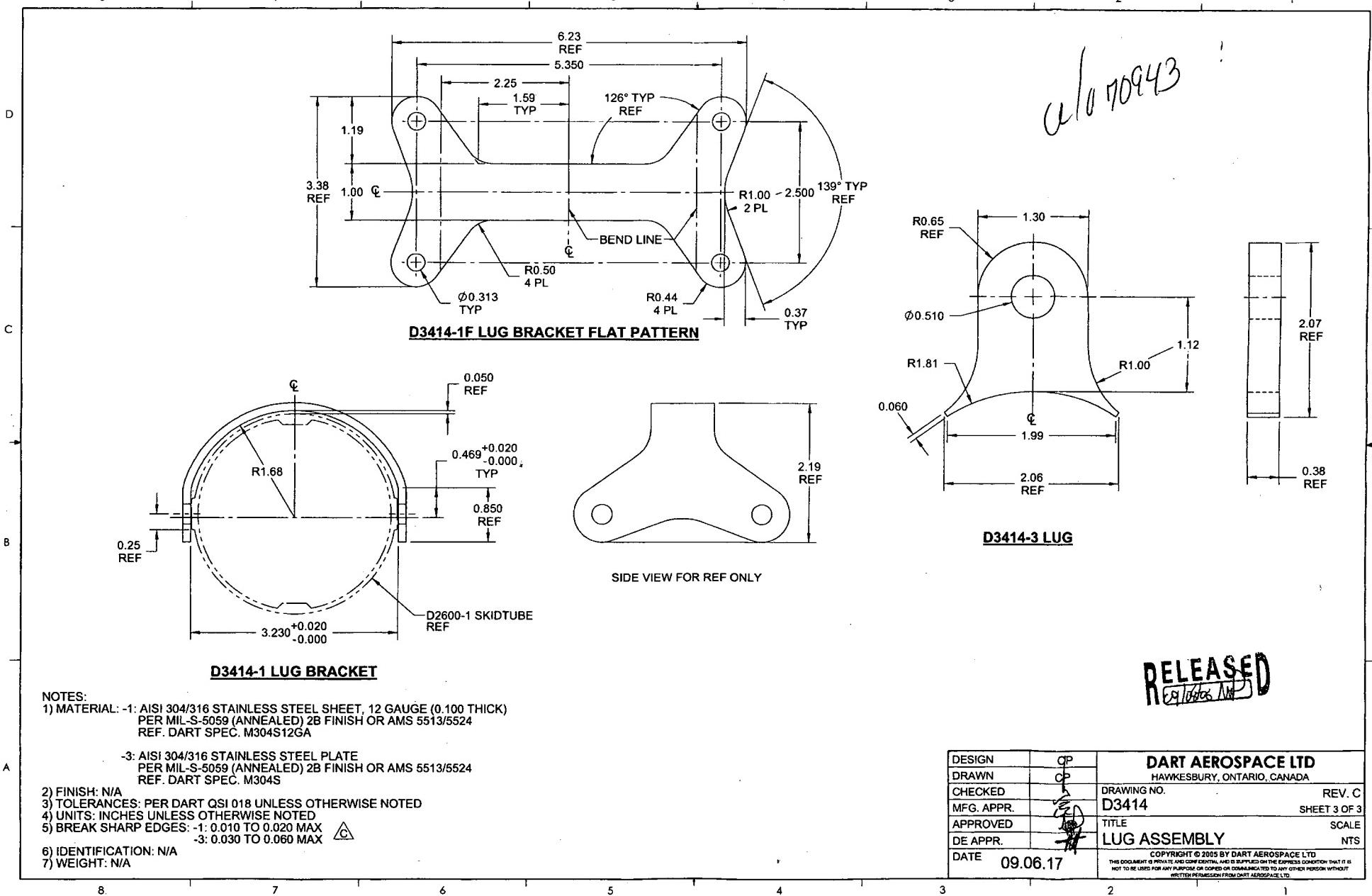
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8 7 6 5 4 3 2 1



DESIGN	QP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.	✓	REV. C	
APPROVED	AP	D3414	
DE APPR.	✓	TITLE	
DATE	09.06.17	SCALE	
		LUG ASSEMBLY	
NTS			

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RELEASED
E910604

W/O:		WORK ORDER CHANGES					
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